

Date: Thursday, 2/22/2007 2:50:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 STEP INSTALLATION
Job Number	: 30795		
Estimate Number	: 10126		
P.O. Number	: N/A	Part Number	: D119675011
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 26197	Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <u>07.02.23</u>	Qty:	3 Um: Each
Comment	: Est Rev:D Removed Manufacturing JLM 05-11-01		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	30795A	A119 STEP WELDMENT LH
-----	--------	-----------------------



Comment: Sub-Component A119 STEP WELDMENT LH

2.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 119-675011 CHG002

③

KS 07.03.05

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

4.0	D2182B032	Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B032 Rubber Cushion

B30872 ✓

5.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

B30875 ✓

7/5/16 SG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION

Job Number: 30795

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26173

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing

B2991 ✓

7.0

D26175

Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing

B31618 ✓

8.0

D2856600766

Abrasion Strip



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D2856-600-766 Abrasion Strip

B26650 ✓

9.0

D30411

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-1 Clamp

B26217 ✓

10.0

D30413

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp

B30890 ✓

11.0

D30421

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

B30891 ✓
B18845 ✓
7/5/16 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 2/22/2007 2:50:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION

Job Number: 30795

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 D3042-1 Clamp

12.0

D3043041

A119 STEP WELDMENT LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

1 D3043-041 Step Weldment LH 30795A

13.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-10A Bolt M101291

14.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt M102280

15.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt M104072

16.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M102929

7/5/16 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 2/22/2007 2:50:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION

Job Number: 30795

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

1 paperwork package from Step 1

M103914 X

2/5/16 SP

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2/5/17 C 207105117 (3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-011

Location:

REV: B

2/5/17 (3) SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/5/18 (3)

Job Completion



1/17/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2119-675-01

Dart Aerospace Ltd.

Date: Thursday, 2/22/2007 2:50:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : A119 STEP WELDMENT LH
Job Number : 30795A	
Estimate Number : 10122	
P.O. Number : <i>N/A</i>	Part Number : D3043041
This Issue : 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3043 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 30591	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/30/2007 Qty: 3 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.02.23	
Comment : Est Rev : A New Issue JLM 05-11-01	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
 Pick: D2622-120 extrusion
 Batch: *329607*

PL 07.03.03

3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

PL 07.03.03

3

2-Deburr and bevel ends for welding

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PL 07.03.06

4.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2734 End Cap *329340*

PL 07.03.06

3

5.0	D30401	Mounting Lug
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3040-1 Mounting Lug *324406*

*330888 = 6**PL 07.03.06*

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 30795A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug

330289-6

~~334406-2~~

PE 07.03.06

3

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802

AR AL ROD Batch: M102237

M102225

2-Grind Fwd End Cap weld flush

PE 07.03.18

3

PE 07.03.19

3

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/03

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/03

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(3x)

1-Chemical Conversion Coat as per QSI 005 4.1

M-L 07/05/07

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: M102756

2-Inspect for foreign object as per QSI 024

3-Grind Fwd End Cap weld flush

Remaining H.

PE 07.05-09

3

PE 07.05-09

3

PE 07.05-09

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 30795A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/10 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/10 (3)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FK

07/35/15 (3)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

M-L

07/05/15

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1103706

el

07-05-15 (3)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

FK

07/05/16 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

POAOS-17 (3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RRP 30795 07/05/17 (3) SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 27/5/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 30795A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

D0705/18

Job Completion



U D0705.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05

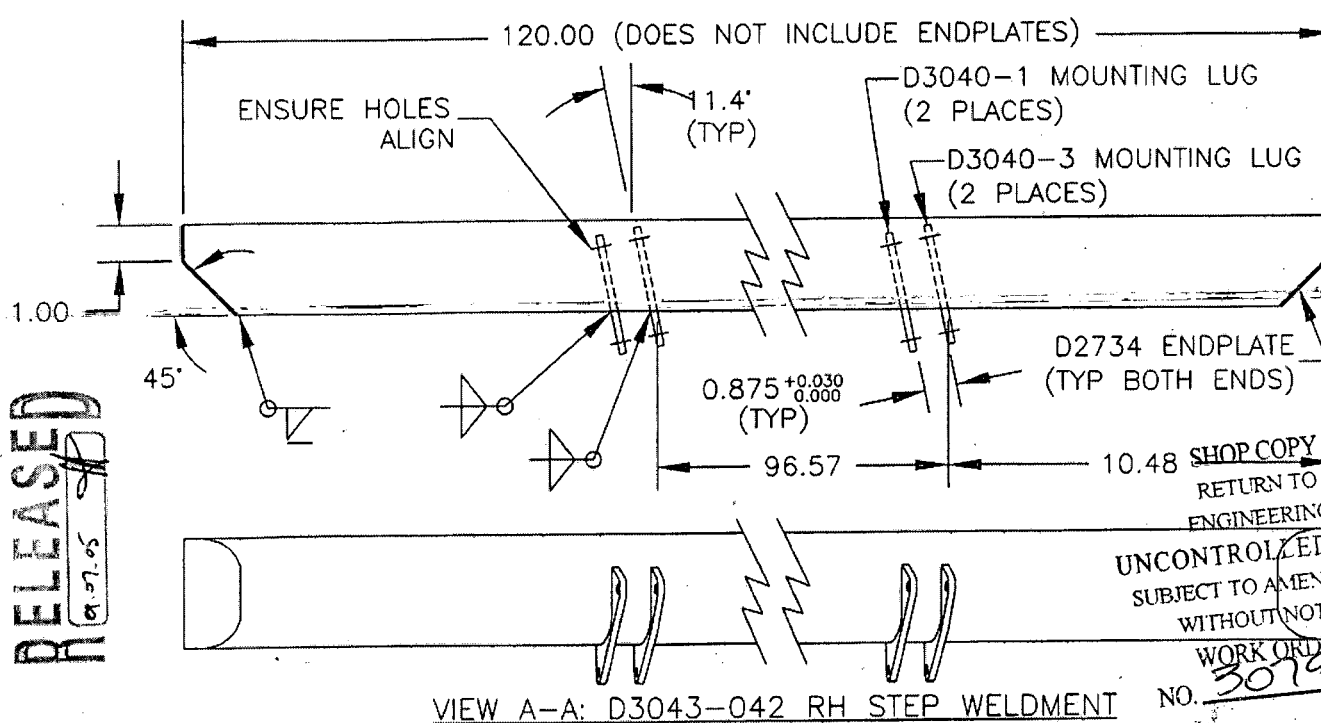
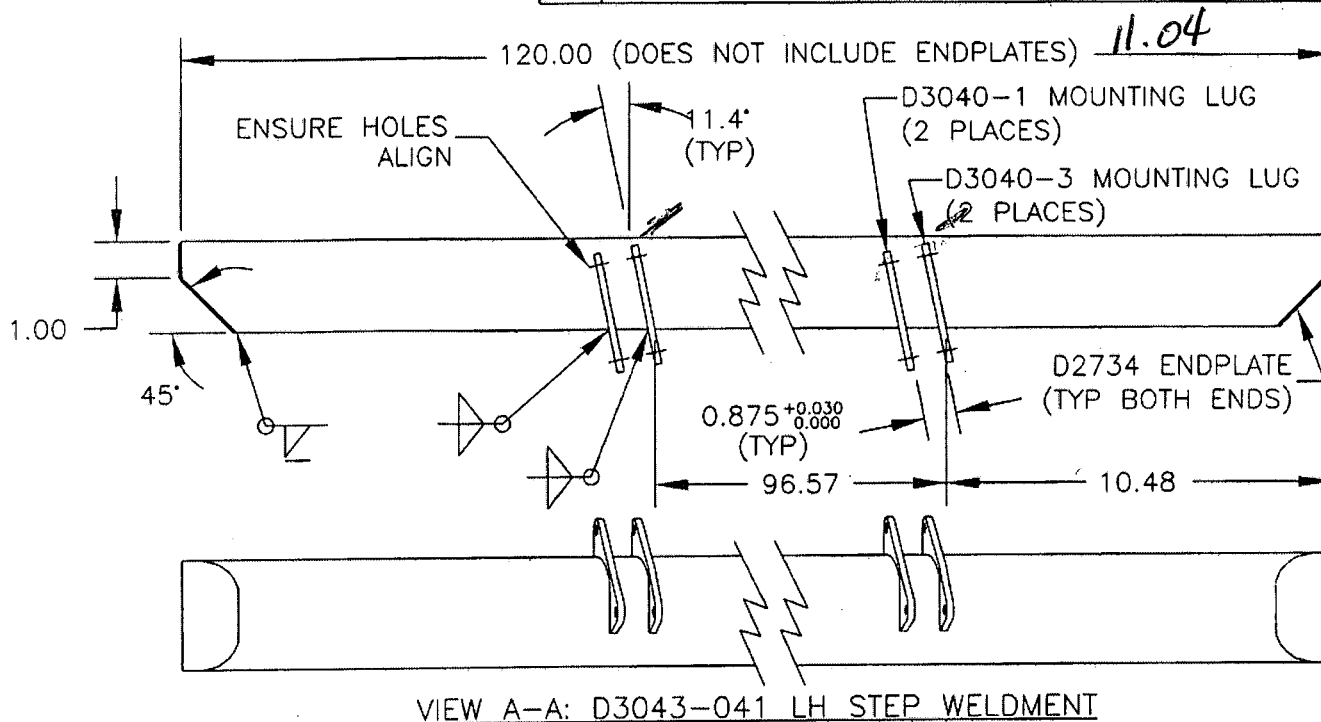
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



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